



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D350-567-143
Job Sheet 184084



Part No: D350-567-143

Job Qty: 1 ea

Part Name: Floor Window Close Out (Energy Attenuating Seats)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/2/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F IPP REV:A 13.04.01 AS PER DSI9590 REV.E DD VERF:JLM

Ship Via:

6056

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Stores/Pkg-2		OCT 24 2018
110	Packaging	1 pcs	11/23/18	11/23/18	0.00	0.00	Packaging1-3		OCT 24 2018
120	QC	1 pcs	11/23/18	11/23/18	0.00	0.00	QC4		
130	Packaging	1 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-1		
135	DC	1 pcs	11/23/18	11/23/18	0.00	0.00	DC		
140	QC21-FG	1 Ea	11/23/18	11/23/18	0.00	0.00	QC21		

Part Op 130 - Identify and pack for shipping as per PPP D350-567-143 Location: _____

Descriptions: 135 - Photocopy bluefile & type labels per PPP D350-567-143 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-3A	Bolt	5 Ea (5 ea)	90-Start up Operation	5072462
AN525-10R6	Screw	2 Ea (2 ea)	90-Start up Operation	5081307
AN525-832R7	Screw	2 Ea (2 ea)	90-Start up Operation	5081346
D3802-1	Window Seal (\$ Per Foot)	2 ft (2 ea)	90-Start up Operation	5104211
D4434-041	Fwd Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	5072241
D4434-047	Cover Assembly	1 Ea (1 ea)	90-Start up Operation	5068704
D4435-9	Bracket	2 Ea (2 ea)	90-Start up Operation	5110402
D4436-041	Aft Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	5083014
D4441-1	Rubber Seal	2 ft (2 ea)	90-Start up Operation	5092167
D4971-041	T/R Bellcrank Cover Assembly	1 Ea (1 ea)	90-Start up Operation	5102019
MS21042L06	Nut	7 Ea (7 ea)	90-Start up Operation	5095637
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation	5100409
MS21042L3	Nut	5 Ea (5 ea)	90-Start up Operation	5004592
MS21059L3	Nut Plate	2 Ea (2 ea)	90-Start up Operation	5071262
MS35206-229	Screw	7 Ea (7 ea)	90-Start up Operation	5067268
NAS1149F0332P	Washer	10 Ea (10 ea)	90-Start up Operation	5109991
NAS1149FN616P	Washer	14 Ea (14 ea)	90-Start up Operation	5064885
NAS1149FN816P	Washer	2 Ea (2 ea)	90-Start up Operation	5089462

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-3A	5	293	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

Q

Date: _____

Work Order update only ☐

Dart Aerospace Ltd.
1270 Aberdeen Street
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TEL: 1 513 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S120901

Part: D350-567-143

Job No: 184084

Serial No/Batch: S120901

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-18 Issue 6 Ref AA-STC SH989NE

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Thermoforming ☐
Large Fab ☐
Cross tube ☐
Small Fab ☐
Finishing ☐
Composite ☐
Water Jet ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Supplier ☐
Engineering ☐
Quality ☐
Other ☐

Step #:

QTY Effective :

MRB (QSI042) Approval

n Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause

Environment ☐
Design ☐
Doc/Data ☐
Equip/Tooling ☐
Handling/Pre ☐
Material ☐
Internal Transport ☐
Tribal Knowledge ☐
LOA ☐
Substation ☐
Past Expiry Date ☐
Misidentified ☐
No Re-verification ☐
Operator ☐
Offset/Setup ☐
Supplier ☐
Training ☐
Use for Testing ☐
Poor Information ☐
Rushing ☐
Product Improvement ☐
Process Improvement ☐
Manufacturing Process ☐
Past Due ☐

Pressure/Forced ☐
Bending ☐
Centre Not Concentric ☐
Cracks ☐
Crimp/Kink/Ripple/Wave ☐
Cuffs ☐
Crushing ☐
Heat Treat ☐
Wave/Twist in Tube ☐
Marks/Chatter ☐

FAULT CATEGORY

Temperature/Cure ☐
Set-up ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Inspection Incomplete/Unqualified ☐
Contamination ☐
Countersink ☐
Cut Too Short ☐
Instructions Incomplete/Unclear ☐
Drill Holes ☐
Power Loss/Surge ☐
Folio/Program ☐
Grain ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set ☐
Misabeled ☐
Fit/Function ☐
Misaligned/off center ☐
Positioned Wrong ☐
Outside Dimensions ☐
Over/Under tolerance ☐
Part Incorrect ☐
Part Lost/Missing ☐
Part Moved ☐
Drawing ☐
Finish ☐
Misread ☐
Turning Sequence ☐

OTHER :

AN525-10R6	2	144	0
AN525-832R7	2	95	0
D3802-1	2	149	0
D4434-041	1	3	0
D4434-047	1	8	0
D4435-9	2	8	0
D4436-041	1	4	0
D4441-1	2	547	0
D4971-041	1	5	0
MS21042L06	7	96	0
MS21042L08	2	2,440	0
MS21042L3	5	2,933	0
MS21059L3	2	208	0
MS35206-229	7	95	0
NAS1149F0332P	10	3,011	0
NAS1149FN616P	14	201	0
NAS1149FN816P	2	188	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 D350-567-115 - OK to remove D3295-041
 D350-567-031 - OK to remove D3212-1
 D350-567-011 - OK to remove D2214
 D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	A/S		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Change Record

PAGE 1 OF 1

Part Number: D350-567-143

Description: FLOOR WINDOW CLOSEOUT (ENERGY ATTENUATING SEATS)

[illegible]

